Work Order ID 117650

April-30-14 10:26:27 AM

117650

Item ID:	D3595-063-450
Revision ID:	
Item Name:	Rubber Cushion

Accept   ***N9000401 00***   Setup   Start   ***NS1***

                                               Stop   ***NS2***

Start Date:	4/30/14	Start Qty:	100.00
Required Date:	5/07/14	Req'd Qty:	100.00

100
100

Cust Item ID:
Customer:

Reference:

                                          Run   Start   ***NR1***

Approvals: Process Plan: _MLS_   Date: _14-04-30_ | Tooling: _____ Date: _____

                                             Stop   ***NR2***

QC: _____ Date: _____ | SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3595	Rev A								

100 ***100*** Waterjet FLOW CNC Waterjet Neo 80.125"	FLOW WATER JET **Memo** 1-Cut as per Dwg D3595 Dwg Rev: _Rev A_ Prog Rev: _A_ 2- Deburr if necessary	0.00 0.00				(151)		mm ✗ -14/05/03	
110 ***110*** QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00						mm ✗ -14.05.03	
120 ***120*** QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00 14|S|S					/S/	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐ Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐ Other ☐
Large Fab ☐	Composite ☐	Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function

- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence

- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____
_____
_____

Work Order ID   117650

April-30-14 10:26:27 AM

117650

Item ID:	D3595-063-450
Revision ID:	
Item Name:	Rubber Cushion

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date:	4/30/14	**Start Qty:** 100.00	***100***
Required Date: 5/07/14		**Req'd Qty:** 100.00	***100***

Cust Item ID:

Customer:

Reference:

Run Start ***NR1***

Stop ***NR2***

Approvals: Process Plan: _____ Date: _____   Tooling: _____ Date: _____

QC: _____ Date: _____   SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 ***130*** Packaging Packaging	Identify as per dwg & Stock Location: LG051 Memo	0.00 0.00				151x	DAS 28 9-89		MAY 05 2014
140 ***140*** QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						_MLJ_ 1405-06	

MLJ 14-05-05

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____   Work Order update only ☐

Work Order: _____	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**
Part No. _____	Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐
NCR No. _____		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function

- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence

- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____
_____
_____

Picklist Print

April-30-14 10:26:31 AM

Work Order ID: 117650

Parent Item: D3595-063-450

Parent Item Name: Rubber Cushion

117650
D3595-063-450

Start Date: 4/30/14   Required Date: 5/07/14
Start Qty: 100.00   Required Qty: 100.00

Comments: IPP Rev:A   New Issue 07-08-07   JLM   Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO80S.125		Purchased	No			100	sf	723.5344	0.0196	3	mm	14/05/03	
									**				

MNEO80S 125
NEOPRENE SHEET 0.125

Location	Loc Qty	Loc Code
MAT052	723.5344	
115916	131.1044	
94539	592.43	5.0

DQA: _____ Date: _____

DART AEROSPACE

QA Closed: _____ Date: _____   Work Order update only ☐

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

DART AEROSPACE LTD		Work Order:	117650
Description: Rubber Cushion		Part Number:	D3595-063-450
Inspection Dwg: D3595 **Rev:** A			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	**First Article**		**Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.63	+/-0.030	6.2				
4.50	+/-0.030	4.50				
0.125	+/-0.010	0.125				
				DAS		
				27 9-39		

Measured by:	_mm KV._	Audited by:		Prototype Approval:	N/A
Date:	14/05/03	Date: 19/5/5		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.23	New Issue	KJ/EC/DD	

H:\FORMS\Quality Assurance\approved QA\FAI revD

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

⩗DART AEROSPACE

QA Closed: _____ Date: _____   Work Order update only ☐

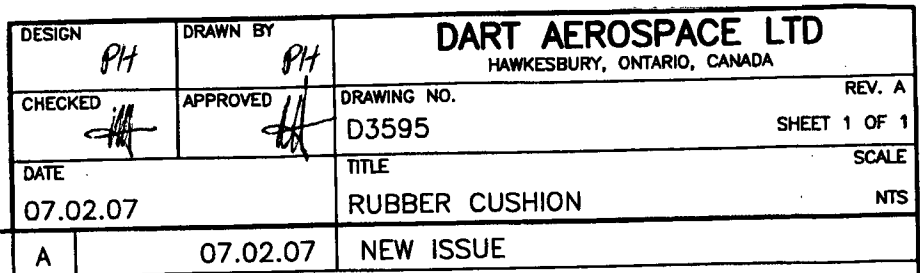| Work Order: _____	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
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Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☐ Other
Inspection Strip in Tube	☐ Drawing	☐ Misread		
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set		
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	_____	
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	_____	

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3595	SHEET 1 OF 1
DATE		TITLE	SCALE
07.02.07		RUBBER CUSHION	NTS
A	07.02.07	NEW ISSUE	

RELEASED
07.02.14

SPECIFICATION CONTROL DRAWING

WIDTH
(REF)

0.125
(STOCK, REF)

LENGTH
(REF)

SPECIFICATION: D3595–XXX–YYY RUBBER CUSHION

WIDTH

LENGTH

EG: 0.75"x4.30" RUBBER CUSHION = D3595–075–430

117650MCT
14-04-30

NOTES

1) MATERIAL: BLACK NEOPRENE SHEET, 0.125 THICK,
80 DUROMETER (REF DART SPEC. M–NE080–S.125)

2) FINISH: NONE

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

⟍DART
AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____   Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear
- ☐ Bending
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- ☐ Other

_____
_____
_____